

Date: Monday, 11/6/2006 2:39:24 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: BUSHING		
Job Number	: 29332					
Estimate Number	: 10725					
P.O. Number	: N/A			Part Number	: D2652	
This Issue	: 11/6/2006			Drawing Number	: D2652 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A	
Previous Run	: 29227			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 11/27/2006	
Checked & Approved By	: <i>[Signature]</i> 06/11/07			Qty:	400	Um: Each
Comment	: Est Rev B 02.06.13 Now machined in house. NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0500	303 Round Bar 0.500"	<i>PP</i>
		Comment: Qty.: 0.0578 f(s)/Unit Total : 23.1000 f(s)	
		Material: 303 ss .500" Round Bar	
		(M303R0500) <i>REMOVED</i>	
		Batch: M101926 2bars 20	<i>J.F 06/11/16</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	<i>J.F 06/11/16</i>
		Comment: HARDINGE CNC LATHE SMALL	
		1-Turn as per Folio FA250 & Dwg D2652	
		2-Deburr	<i>J.F 06/11/16</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	<i>DJP 136 06.11.16 400</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	<i>SD 06.11.16 400</i>
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	<i>100/100 200</i>
		Comment: PACKAGING RESOURCE #1	
		Identify and Stock	
		Location: ST 54	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/21
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/21	1	Used 304 instead of 303 - acceptable per attached Email New employee.	JD 06/11/21	ensure employee verifies the material required is correct. Material (304) is Acceptable. See E-mail.	J.F 06/11/21	06/11/21	BB 06/11/21	J.F 06/11/21

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29332

Part Number: D2652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



400

Comment: FINAL INSPECTION/W/O RELEASE

06/11/01

Job Completion



Ude-11.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29332
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

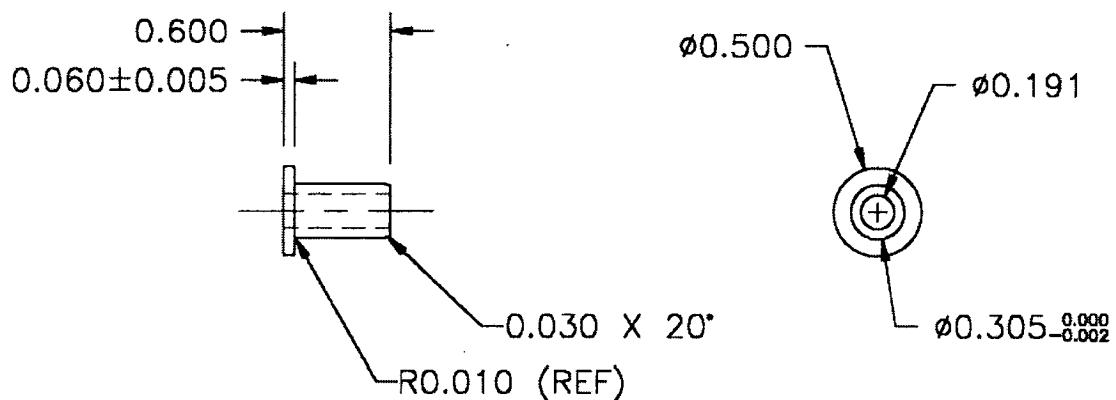
X First Article Prototype

Measured by: <u>J.F./gml</u>	Audited by: <u>J.S.L.</u>	Prototype Approval:	N/A
Date: <u>06/11/16</u>	Date: <u>06/11/16</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	IT

DART

DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>BB</i>	APPROVED <i>BB</i>	DRAWING NO. D2652 REV. A SHEET 1 OF 1
DATE 97/03/25	TITLE BUSHING	SCALE 1:1

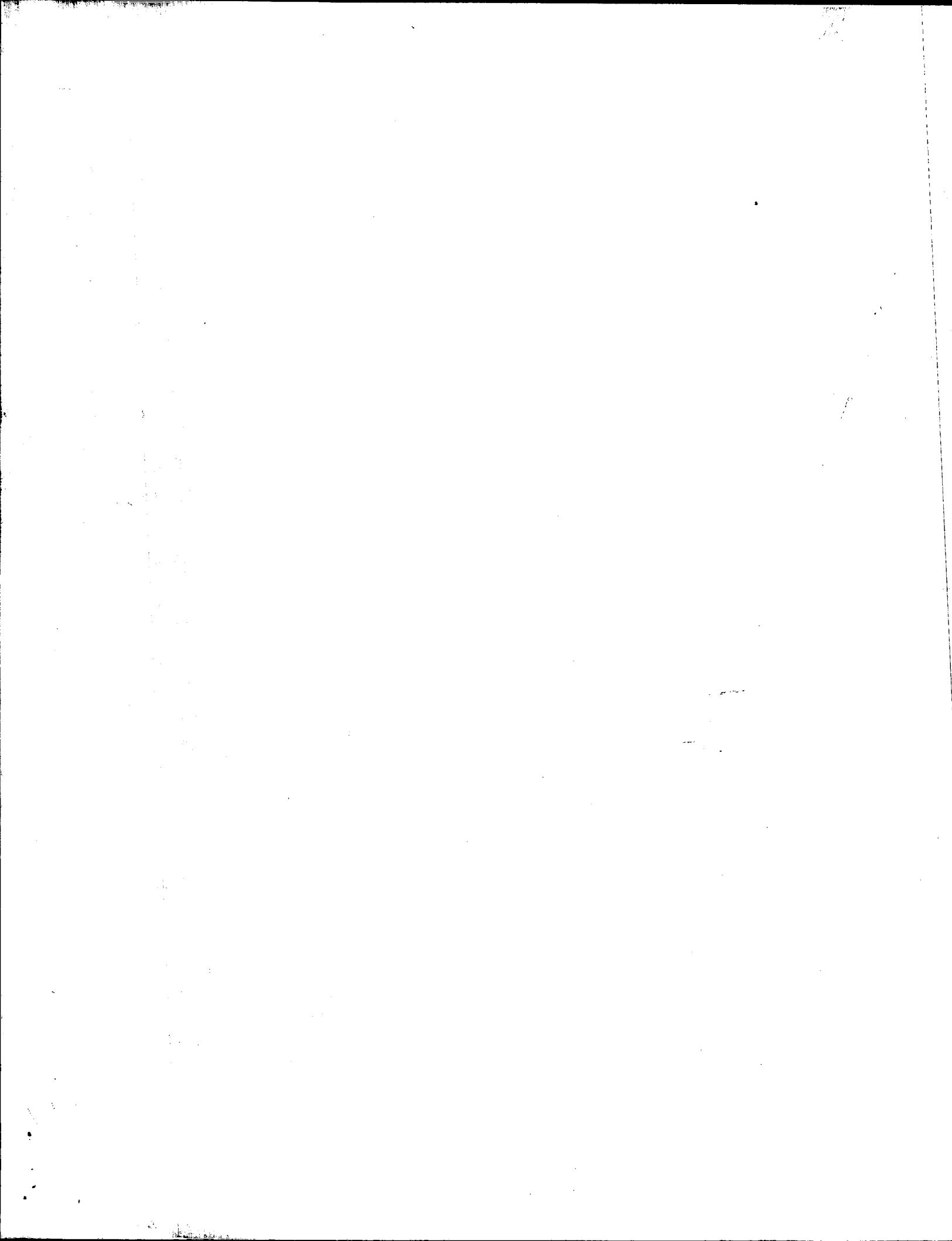
RELEASED
97/04/25 DS

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

NOT TO COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
29332



L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 21, 2006 9:57 AM
To: 'L Lacelle'; 'S Shahbazian'
Cc: 'Jason Murdoch'
Subject: RE: D2652

As long as the parts turned OK, these parts are acceptable.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, November 21, 2006 6:58 AM
To: *David Shepherd (*David Shepherd); S Shahbazian
Cc: Jason Murdoch
Subject: D2652

Hi David,
One of the new guys made D2652's out of 304 round bar instead of 303 round bar....are these acceptable ?
LL

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.14.10/541 - Release Date: 11/20/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.14.10/541 - Release Date: 11/20/2006